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D2739
Job Sheet 204298



Part No: D2739

Job Qty: 5 pcs

Part Name: 350 I-Beam



Part Weight: 0 lbs

Job Created: 12/5/19

Due Date: 1/3/20

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	5 pcs	1/3/20		0.00	5.80	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	5 pcs	1/3/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	5 pcs	1/3/20		0.00	0.42	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		



Container No: S245804



Part: D2739

Job No: 204298

Serial No/Batch: S245804

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/08/20

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130 QC 7	5 pcs	1/3/20	0.00 0.00	Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
140 Packaging 3-1 - Stock - B4B	5 pcs	1/3/20	0.00 0.00	QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
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					Packaging 3 - 21 - B4B					
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					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B	BE				
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					150 QC 21 - SA	5 pcs	1/3/20	0.00 0.00	QC 21 - SA - 21	DAS
									QC 21 - SA - 70	21
									QC 21 - SA - 53	5-00 JAN 10 2023

Part Op 100 - (Skidtubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per
Descriptions: Dwg D2739 3-Use unl-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes
and ends.
110 - QC5- Inspect part completeness to step on W/O
120 - (Chemical Conversion Coat per QSI005 4.1)
130 - (QC7- Inspect Chemical Conversion Coat)
140 - (Identify as per dwg & Stock Location: 16002) LOCATION : LG002
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	5 pcs (1 ea)	100-Skidtubes - 1	S146203

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2600-5-108	5	142	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100 10.040		
10	Web	12.990Inches ± 0.030	13.020 12.960		
11	Web	16.540Inches ± 0.030	16.570 16.510		
12	Web	20.870Inches ± 0.030	20.900 20.840		
13	Web	25.200Inches ± 0.030	25.230 25.170		
14	Web	29.530Inches ± 0.030	29.560 29.500		
15	Web	32.650Inches ± 0.030	32.680 32.620		
16	Web	33.860Inches ± 0.030	33.890 33.830		
17	Web	35.350Inches ± 0.030	35.380 35.320		
18	Web	38.280Inches ± 0.030	38.310 38.250		
19	Web	41.350Inches ± 0.030	41.380 41.320		
20	Web	44.350Inches ± 0.030	44.380 44.320		
21	Web	47.400Inches ± 0.030	47.430 47.370		
22	Web	50.150Inches ± 0.030	50.180 50.120		
23	Web	52.900Inches ± 0.030	52.930 52.870		
24	Web	64.060Inches ± 0.030	64.090 64.030		
25	Web	70.270Inches ± 0.030	70.300 70.240		
26	Web	73.020Inches ± 0.030	73.050 72.990		
27	Web	75.770Inches ± 0.030	75.800 75.740		
28	Web	56.150Inches ± 0.030	56.180 56.120		

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Job: _____		DISPOSITION			DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-Is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)						
Description Work Order Deviation				Disposition								
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread								